

Work Order ID 113887

February-25-14 7:44:29 AM

Split 10

113887

Page 1

Item ID: D2940-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 2/25/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *14-02-25*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2940

C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA079
2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
44
9-89

14/04/28

DAS
02
9-89

14.04.22

14.04.23

Q10

DAS
02
9-89

14.04.22

14.04.23

14.04.24

14.04.20

9

14.04.20

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AA Date: 14/06/03QA Closed: AA Date: 14/5/29

Work Order: <u>113887</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2940-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3906</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>	14-04-22	100	x1	tool holder did not clamp properly during tool change. Tool holder remained extended out of spindle by over 0.500", causing tool to hit part gauge part by approx 0.060" (in location where helicopter sits)	DAS 22 9-89 14-04-23	SCRAP, DESTROY, NO REPLACE. \$192.29	RT 14-04-23	14/04/23	27 9-89 14/4/03
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input checked="" type="checkbox"/> Other <u>Tool</u>
		<u>change Failure HAAS #2</u>

Work Order ID 113887

February-25-14 7:44:20 AM

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Page 2

Item ID: D2940-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 2/25/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/08/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Handl Xtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2940. Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

9 0 0 AS
14-5-5

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
27
9-33
14/5/6

9

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: LG051

0.00

Memo

0.00

9X

DAS
28
9-33

MAY 06 2023

Work Order ID 113887

February-25-14 7:44:20 AM

113887

Page 3

Item ID: D2940-i

Revision ID:

Item Name: Support

Start Date: 2/25/14 Start Qty: 20.00

Required Date: 4/08/14 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Accept

Tooling:

SPC (Y/N):

Set Up/
Run Hours

0.00

0.00

N9000040100

Cust Item ID:

Customer:

Date:

Date:

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

MLJ 14-05-08

PH 14-05-07

Picklist Print

February-25-14 7:44:27 AM

Page 1

Work Order ID: 113887

113887

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 2/25/14

Required Date: 4/08/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C 02.11.26 Reformat: Added P/OKJ

IPP Rev:D Added priming as per Rev B 07-04-30 JLM

IPP E 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	15.0000	0.5	11			

DSK081

D2940-1 Turning Detail

**

14.04.16

Location

Loc Qty

Loc Code

MAT060

15

109170

5

110384

10

10

DART AEROSPACE LTD		Work Order: 113887
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AB	0.490	0.510		R.500	R.500	R.500	R.500	R.500
AC	0.140	0.160		.155	.156	.154	.154	.155
AD	3.510	3.530		3.514	3.513	3.514	3.512	3.514
AE	1.633	1.673		1.656	1.657	1.657	1.663	1.660
AF	1.493	1.513		1.506	1.505	1.506	1.506	1.511
AG	0.040	0.060		.050	.050	.050	.050	.050
AH	0.188	0.193		Ø.188	Ø.189	Ø.188	Ø.188	Ø.188
AI	0.140	0.160		.150	.150	.150	.151	.149
AJ	2.518	2.538		2.524	2.524	2.524	2.520	2.520
AK	0.040	0.060		.045	.045	.045	.045	.045
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.149	.151	.149	.150	.151
AN	0.350	0.450		.379	.380	.380	.385	.385
AO	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AP	0.150	0.170		.157	.156	.157	.154	.155
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.121	4.121	4.121	4.121	4.121
AV								
AW								
Accept/Reject								

Measured by: *JP*

Date: 14.04.20

Audited by: *FX*

Date: 14/04/20

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>JP</i>

DART AEROSPACE LTD		Work Order: 113887
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
HAAS Section								
AA	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AB	0.490	0.510		R.500	R.500	R.500	R.500	R.500
AC	0.140	0.160		.154	0.148	0.150	0.146	0.151
AD	3.510	3.530		3.512	3.516	3.516	3.515	3.514
AE	1.633	1.673		1.657	1.659	1.659	1.657	1.656
AF	1.493	1.513		1.506	1.508	1.508	1.506	1.505
AG	0.040	0.060		.050	0.051	0.049	0.049	0.051
AH	0.188	0.193		Ø.188	Ø.188	Ø.188	Ø.188	Ø.188
AI	0.140	0.160		.151	0.151	0.151	0.151	0.151
AJ	2.518	2.538		2.520	2.526	2.526	2.526	2.526
AK	0.040	0.060		.045	0.051	0.051	0.054	0.053
AL	0.010	0.020		0.15	.015	.015	.015	.015
AM	0.140	0.160		.149	0.150	0.146	0.148	0.150
AN	0.350	0.450		.385	0.400	0.400	0.400	0.400
AO	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AP	0.150	0.170		.156	0.151	0.151	0.151	0.151
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.121	4.134	4.136	4.130	4.132
AV								
AW								
Accept/Reject								

Measured by: 18 / DAS 02 8-89	Date: 14.04.21
Audited by:	Date: 14/04/21
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order: 113 887
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/	2/	3/	4/	5/
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.152	0.153	0.154		0.153
AD	3.510	3.530		3.512	3.512	3.516		3.517
AE	1.633	1.673		1.658	1.657	1.658		1.661
AF	1.493	1.513		1.505	1.507	1.510		1.508
AG	0.040	0.060		0.050	0.050	0.050		0.050
AH	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AI	0.140	0.160		0.149	0.152	0.154		0.151
AJ	2.518	2.538		2.526	2.528	2.528		2.526
AK	0.040	0.060		0.052	0.051	0.051		0.050
AL	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AM	0.140	0.160		0.148	0.148	0.149		0.146
AN	0.350	0.450		0.400	0.400	0.400	0.400	0.400
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.153	0.150	0.152		0.153
AQ	0.053	0.073		0.063	0.063	0.067	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.262	0.262	0.262	0.262	0.262
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.131	4.132	4.132		4.133
AV								
AW								
Accept/Reject							scrapped per PTO	

Measured by: <i>BT</i> ^{DAS} 02 9-89	Date: 14-04-22
Audited by: F.K.	Date: 14/04/28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>BT</i>

DART AEROSPACE LTD		Work Order:	113887
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

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Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		0.250	0.250	.250	.250	.250
AB	0.490	0.510		0.500	0.500	.500	.500	.500
AC	0.140	0.160		0.147	.147	.1475	.1475	.1475
AD	3.510	3.530		3.516	3.515	3.515	3.513	3.516
AE	1.633	1.673		1.661	1.658	1.656	1.656	1.654
AF	1.493	1.513		1.512	1.509	1.509	1.510	1.502
AG	0.040	0.060		0.049	.049	.049	.049	.050
AH	0.188	0.193		0.190	0.190	.190	.190	.190
AI	0.140	0.160		0.151	.151	.152	.153	.15
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		0.051	.050	.051	.051	.051
AL	0.010	0.020		0.010	0.010	.010	.010	.010
AM	0.140	0.160		0.147	.147	.149	.1495	.150
AN	0.350	0.450		0.400	0.400	.400	.400	.400
AO	0.240	0.260		0.250	0.250	.250	.250	.250
AP	0.150	0.170		0.151	.152	.152	.153	.152
AQ	0.053	0.073		0.063	0.063	.063	.063	.067
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.262	0.262	.262	.262	.262
AT	0.053	0.073		0.063	0.063	.063	.063	.063
AU	4.118	4.138						
AV								
AW								
Accept/Reject								

Measured by:	DAS 02 BT / DR	Date:	14.04.23
Audited by:	9-89 FK	Date:	14.04.24
Prototype Approval:		Date:	14/04/28

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

